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Cited documents:

 DE3429092 (A1)

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Abstract of **DE 4445942 (C1)**

The method involves placing stiffener parts (6,7) on different outer skin parts (2) of body panels (3) still connected to each other, after the outer skin parts have been deep drawn. The stiffener parts are welded to the outer skin parts. The stiffened panels are then separated by profile cuts. The stiffener parts are manufactured separately, and individually fastened to the outer skin parts. The different stiffener parts for the outer body panel and the part to be fitted into it, are deep-drawn together and simultaneously from a single steel sheet.